

REVISION HISTORY							
DATE	REV	DESCRIPTION	AUTHOR	CHECKED BY	APPROVED		
06/02/16	PR2	ADDED -19 AND -20 TO THE -100; CHANGED THE -102; ON THE -119 MAKE FROM WAS ES04020-1 AND WIDTH WAS 12.18.	JT	LS	JT		
08/04/16	PR3	UPDATED PICTORIALS OF -100, -10 AND -120; FOR -110, CHANGED LENGTH FROM 22.000 TO 21.624; CHANGED THE -117 TUBE WITH A 5.7° BEND; CHANGED THE -127 FOR HOLE PLACEMENT; REMOVED THE -115; ON THE -122 AND -123, REPLACED THE -115 WITH THE -127; REMOVED DIMS ON -112 FLAT PATTERN SINCE SAME AS -111.	JT	LS	JT		
03/09/17	A	ADDED SHEET 1 FOR THE REVISION BLOCK; UPDATE FINISH ON -101, -102, -103, -104, -105, -106, -108, -110, -111, -112 AND -127; ON -105 CHANGED TOLERANCE ON 12.644 WAS +/-0.010, CHANGED THE 0.266 DIA. HOLES TO SLOTS; ON -110 CHANGED DIM. 20.579 TO 19.534 AND REFERENCE POINT, CHANGED 0.201 DIA HOLES 2 PLACES TO 0.175; ON -111 CHANGED TOLERANCE OF 0.125 DIA. WAS +/-0.010, CHANGED 0.201 DIA HOLE TO 0.175; ON -127 CHANGED RIVET HOLES WAS 0.093/0.103 DIA; ON -20 REMOVED '505AC-601' FROM NOTE 2, CHANGED MINIMUM LENGTH IN NOTE 3 WAS 6', ADDED A WIRING DIAGRAM; ON -109 CORRECTED RIVET SIZE WAS MS20470AD2-2-5; ON -101, -103 AND -106 ADDED DIMENSIONS; ADDED MASK AREAS ON -101,-102, -103, -104, -105, -106, -108, -110, -111, -112 AND -127; UPDATED NOTES AND ADDED BONDED AREA CALLOUTS TO -100, -109, -120, -121, -122 AND -123; ON -100, REMOVED THE MS20470ad3-3-5 RIVETS AS THEY ARE PART OF -120.	JT	LS	JT		
3/29/2017	B	REPLACED NAS1149CO0332R, NAS1149CO463R, NAS1149CN816R WITH NAS1149F_____P; REPLACED MS21043-XX NUTS WITH MS21042-XX NUTS. 505AC-2300 -111 AND -112 MATERIAL THICKNESS WAS .030", ADDED BEND TABLE TO PG 21, -101 TAPE TEST WAS ONCE PER MONTH.	EW	LS	JT		
6/1/17	C	ADDED ITEM 6 SHT 4	EW	LS	JT		
7/19/17	D	FILLED IN CHECKED BY AND APPROVED INITIALS REV PR2 TO C; SHT 2 BOM ITEM 14 WAS MS21042L3, BOM ITEM 21 WAS NAS43DD3-20; SHT 5 BOM ITEM 3 WAS MS20470AD3-2-5; SHT 6 BOM ITEM 4 WAS MS20470AD3-3-5, REV B & C AUTHOR WAS ETW & KEW.	EW	LS	JT		
10/17/17	E	ADDED R0.156 EDGE RELIEF TO -111 AND -112.	EW	LS	JT		
02/20/18	F	SHT 2 ITEM 1 WAS 505AC-2300-010, ITEM 2 WAS 505AC-2300-020, REMOVED ITEM 12, ITEM 20 WAS NAS1149FN816R, ITEM 22 QTY WAS A/R PART NUMBER WAS IUB0IC-33; SHT 3 REPLACED HARDWARE & TUBES WITH NEW -11 & -12 SUB ASSEMS; ADDED NEW SHT 4-11 & -12 DETAILS; SHT 5 ITEM 5 QTY WAS 2, PART NUMBER WAS MIL-W-22759/41-16-8, DESCRIPTION WAS WIRE, ADDED ITEMS 7 AND 8 TO PARTS LIST, ADDED POLARITY NOTES AND PIN NUMBERS TO WIRING DIAGRAM, ADDED NOTE 4; SHT 7 ITEM 4 WAS MS20470AD3-3-5, ADDED ITEM 5; SHT 9 & 10 ADDED NOTE 5; SHT 15 -105 BEND RADIUS WAS 0.040"; SHT 16 -106 BEND RADIUS WAS 0.060"; ADDED BEND CHARTS & BEND CALLOUTS TO -101, -103, -105, -108, -110, -111, -112.	EW	LS	JT		
7/3/18	G	SHT 5 REMOVED 7" LENGTH IN DESCRIPTION OF ITEM 5	ZA	LS	EW		
12/13/18	H	-100 ASSEMBLY: ADDED NOTE 7 ABOUT SLOTS TO ALLOW ITEM 11 SCREWS IN CONDENSER PARTS; -101 & -102: CHANGED LARGE HOLE LENGTH DIMENSION FROM .941 TO .878, ADDED 2X TO DIMENSION ON SHT 11; -105, CHANGED THICKNESS FROM 0.020" TO 0.025", REMOVED THICKNESS CALLOUT ON DRAWING, ADDED 0.05 REFERENCE DIMENSION TO FOLDED TAB DIMENSION IN SECTION C1, ADDED .032 FILETS TO CORNER BENDS;	ZA	LS	ZA		
7/5/19	J	-117 PART: REMOVED FLARE CALLOUT. -12 ASSEMBLY: ADDED FLARE OPERATION.	DT	LS	ZA		
9/3/19	K	-100 ASSEMBLY FIXED ITEM 21 NAME; -116 & -117: INCREASED WALL TOLERANCE TO 3 PLACES, ADDED ALTERNATE ES PART NO.	ZA	LS	ZA		
1/7/21	L	-105 PART: RE-ADDED DETAIL C DIMENSIONS AND MADE CUTOUT LINES SMOOTH FOR CLARITY	ZA	DT	MH		
10/14/21	M	-120: CHANGED EXTRUDED RUBBER LENGTH TO 2.1' WAS 24"	ZA	DT	ZA		

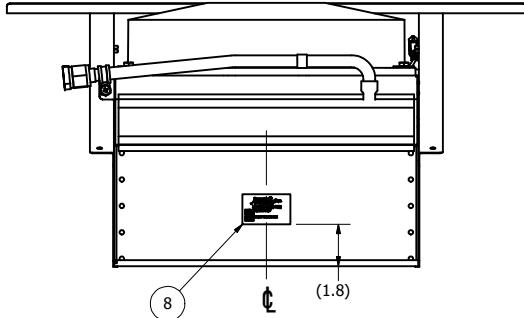
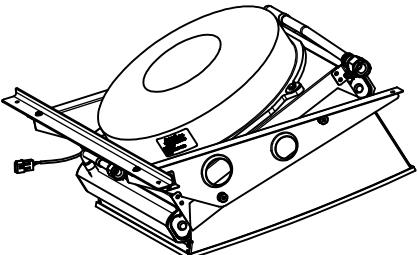
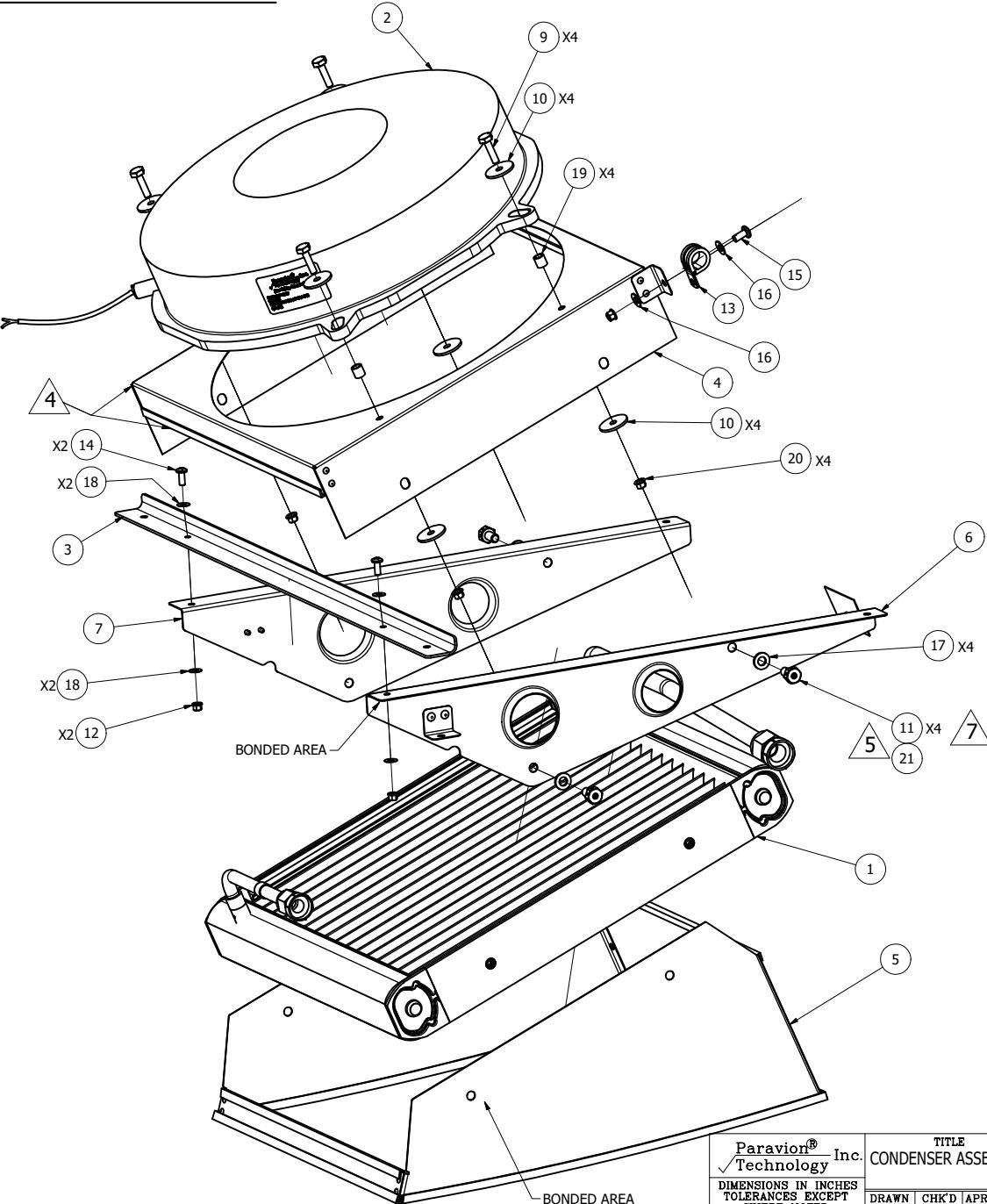
 Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ±.1 .XX = ±.05 .XXX = ±.010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M
DO NOT SCALE DRAWING		3RD ANGLE PROJECTION				ECO
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-10	CONDENSER COIL ASSY
2	1	505AC-2300-20	CONDENSER FAN ASSY
3	1	505AC-2300-110	CONDENSER FORWARD BRACKET
4	1	505AC-2300-120	CONDENSER PLENUM BOX ASSY
5	1	505AC-2300-121	CONDENSER PLENUM ASSY
6	1	505AC-2300-122	CONDENSER LEFT SIDE ASSY
7	1	505AC-2300-123	CONDENSER RIGHT SIDE ASSY
8	1	505AC-6120-1	LABEL
9	4	AN3-6A	BOLT
10	8	AN970-3	WASHER
11	4	MS20074-04-03	BOLT
12	2	MS21042L08	NUT
13	1	MS21919WDG8	ADEL CLAMP
14	2	MS27039-0806	SCREW
15	1	MS27039-1-06	SCREW
16	2	NAS1149F0332P	WASHER
17	4	NAS1149F0463P	WASHER
18	4	NAS1149FN816P	WASHER
19	4	NAS43DD3-20FC	SPACER
20	5	NAS9926-3L	NUT
21	12in	TIUB01C-33	POLY TUBE

## NOTES:

1. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPPED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
2. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
3. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.
4. SEAL MATING SURFACES AND CORNERS WITH BLACK SILICONE RTV.
5. SAFETY USING MS20995 Ø.032 WIRE (& POLY TUBE) PER BHT-ALL-SPM, PARAGRAPH 8-27 THRU 8-29.
6. TORSUE FASTENERS PER BHT-ALL-SPM CHAPTER 4.
7. IF NECESSARY SLOT PART HOLES UP TO .250" IN ANY DIRECTION TO ALLOW ITEM 11 SCREWS TO FIT WITH ITEM 1 CONDENSER. REAPPLY PRIMER TO BARE SURFACES PER MFR'S RECOMMENDATIONS.

**-100 CONDENSER ASSY**

<b>Paravion® Technology Inc.</b> <small>✓</small>		TITLE			DRAWING NUMBER	
		CONDENSER ASSEMBLY			505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M
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PROTO		3RD ANGLE PROJECTION				

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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-11	TUBE ASSY
2	1	505AC-2300-12	TUBE ASSY
3	1	ES90123-1	CONDENSER

3

4

2

1

## NOTES:

⚠ WELD PER EPS-1003 OR BRAZE PER AWS3.4

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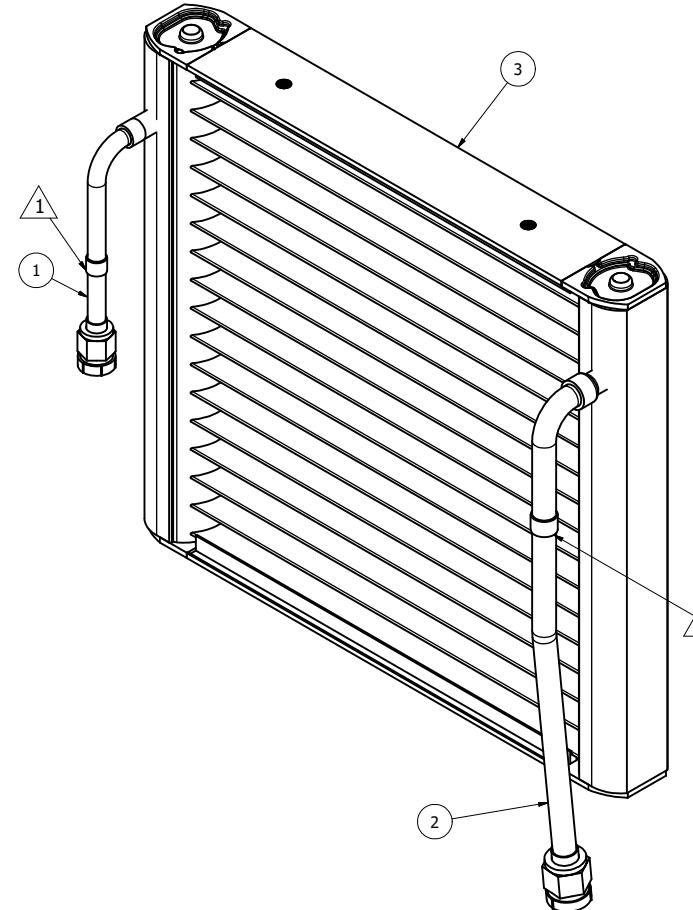
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**-10 CONDENSER COIL ASSY**

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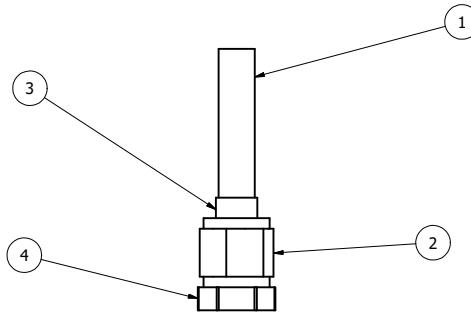
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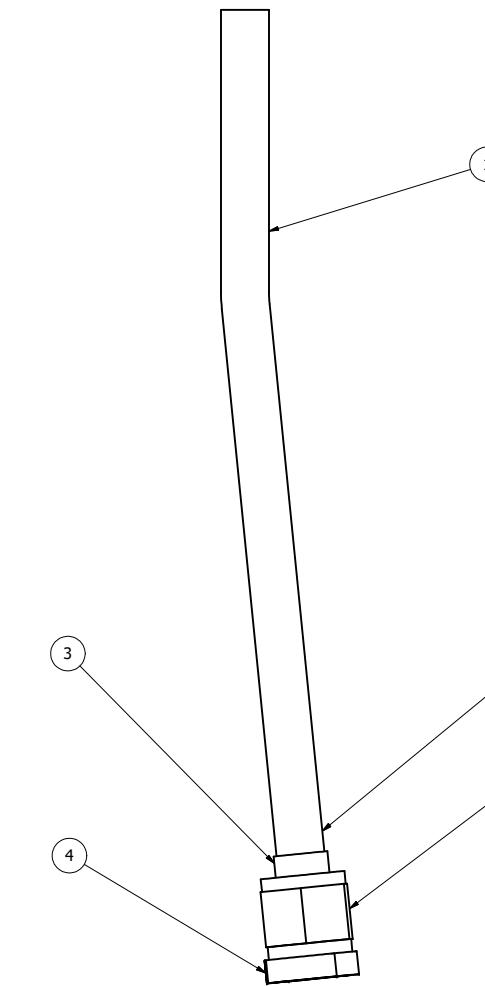
**-11 TUBE ASSEMBLY**

PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-116	TUBE
2	1	AN818-6D	FLARED NUT
3	1	AN819-6D	SLEEVE
4	1	PD60	CAPLUG 3/8" X 9/16-18

**-12 TUBE ASSEMBLY**

NOTES:

⚠ INSTALL ITEMS 2 AND 3; THEN FLARE -117  
37° PER SAE AS4330.

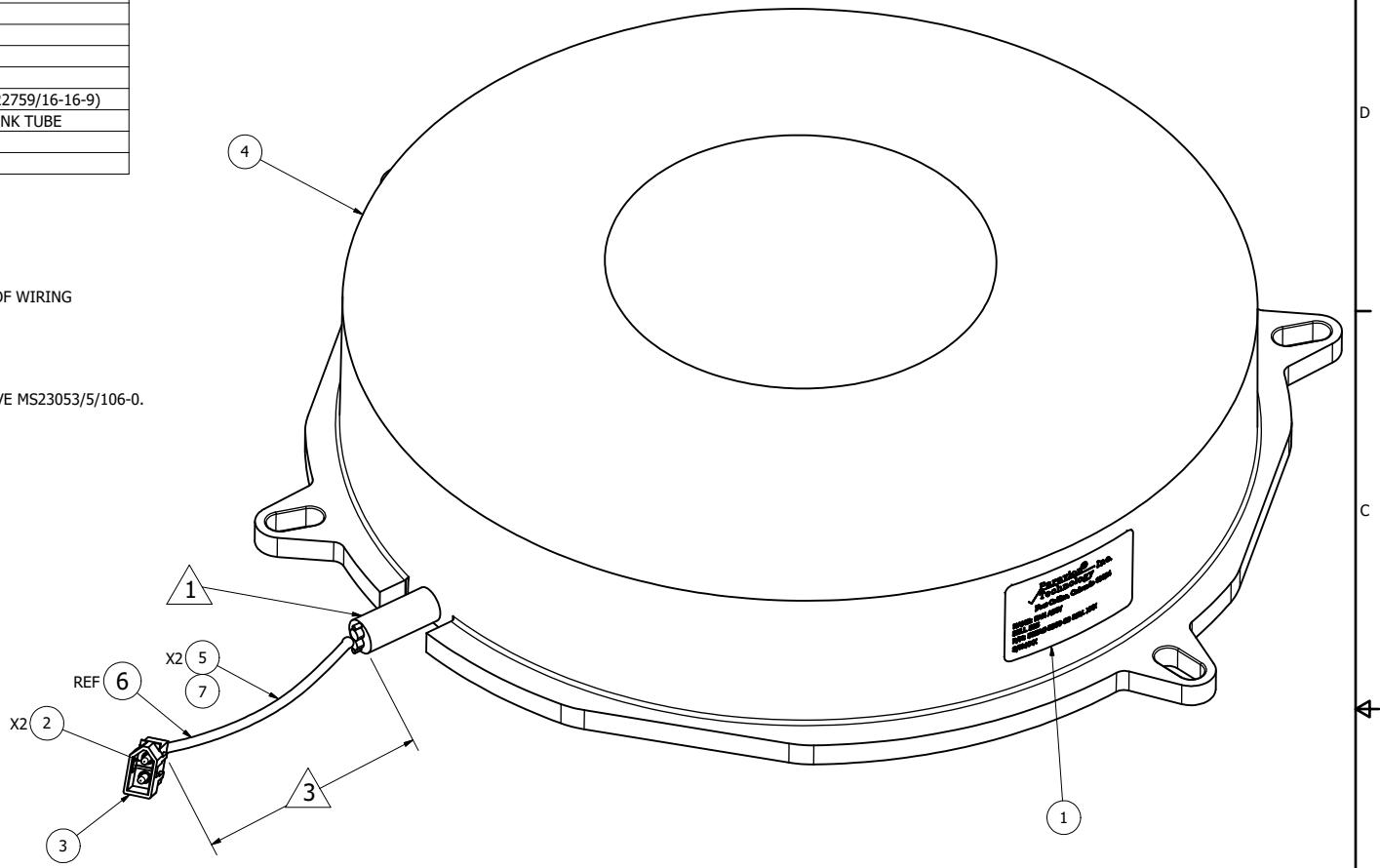


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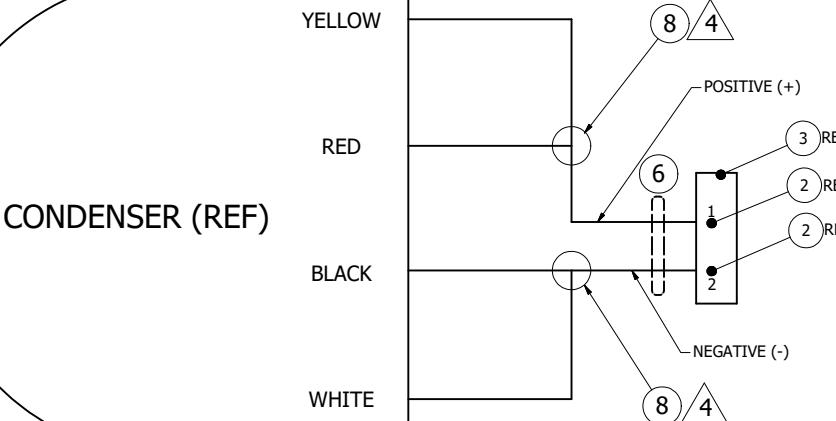
PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-6120-5	LABEL
2	2	ESS50270-2	TERMINAL, MALE
3	1	ESS50272-1	CASE, FEMALE
4	1	ES73201-1	FAN
5	9"	MIL-W-22759/41-16-9	WIRE(ALT. MIL-W-22759/16-16-9)
6	1	505AC-6120-42	2110J1 IDENT SHRINK TUBE
7	6in	M23053/5-107-0	HEAT SHRINK
8	2	M83519/1-3	SOLDER SLEEVE

## -20 CONDENSER FAN MODIFIED

- ⚠ ORIGINAL FAN CONNECTOR TO BE CUT OFF LEAVING BETWEEN 1"-3" OF WIRING
- 2. WIRES TO BE SPLICED ACCORDING TO WIRING DIAGRAM
- ⚠ FINISHED WIRING SHOULD BE APPROXIMATELY 3.5"-8" LONG
- ⚠ TIN WIRES PER MIL-S-4573E BEFORE CONNECTING WITH SOLDER SLEEVE MS23053/5/106-0.



WIRING DIAGRAM FOR SPLICING



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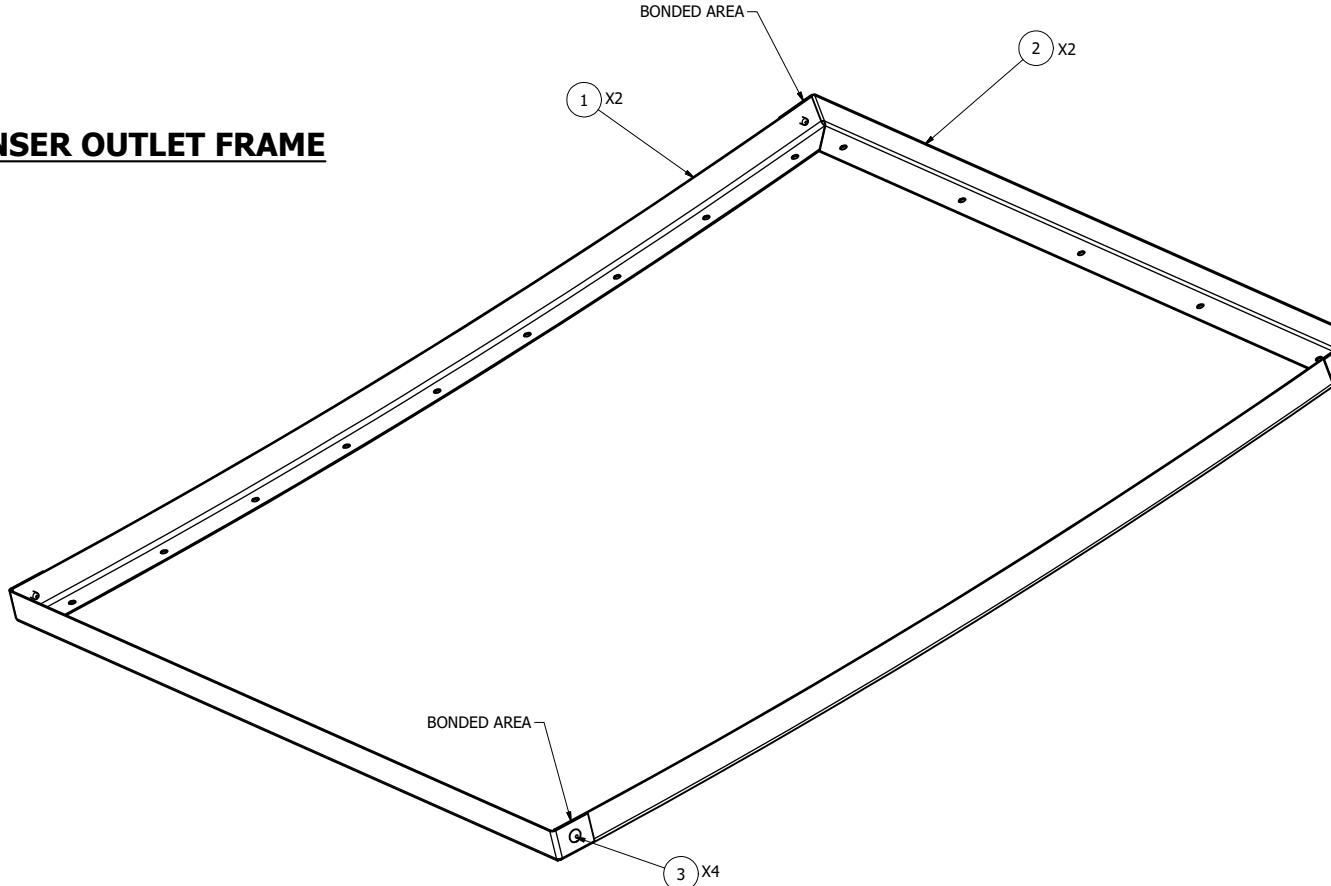
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	2	505AC-2300-106	CONDENSER SIDE FRAME
2	2	505AC-2300-108	FOR/AFT FRAME
3	4	MS20470AD3-2.5	RIVET

## D NOTES:

1. WET INSTALL RIVETS WITH PRIMER PER MIL-PRF-23377J TYPE I, CLASS N
2. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPPED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
3. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
4. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.

**-109 CONDENSER OUTLET FRAME**

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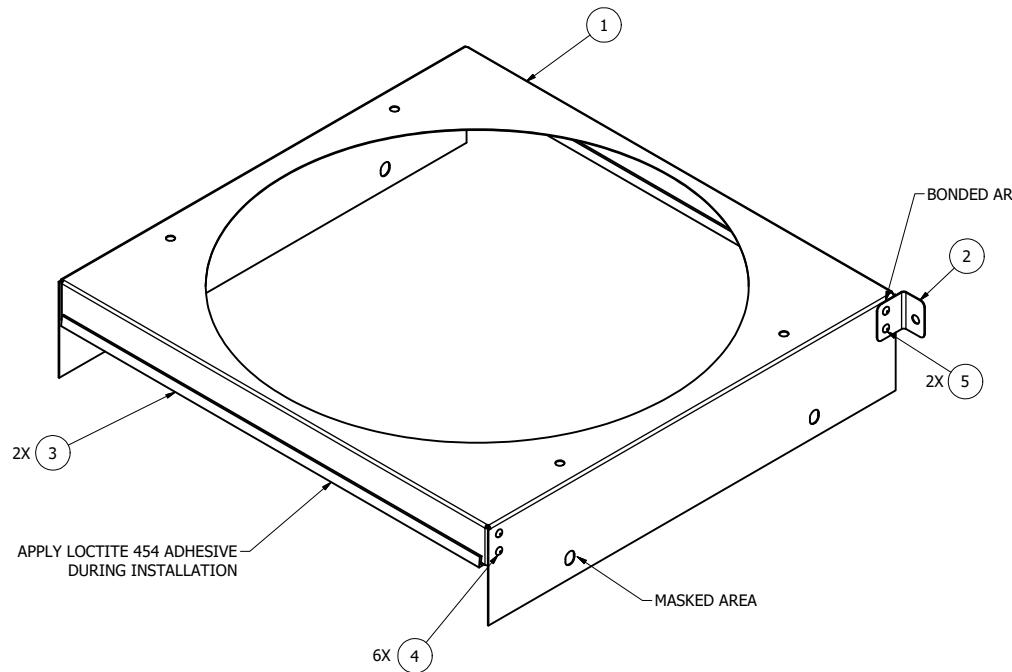
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-105	BOX
2	1	505AC-2300-127	TUBE SUPPORT
3	2.1'	ES00140-3	EXTRUDED RUBBER
4	6	MS20470AD3-2-5	RIVET
5	2	MS20470AD3-3	RIVET

## NOTES:

- WET INSTALL RIVETS WITH PRIMER PER MIL-PRF-23377J TYPE I, CLASS N
- ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPARED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
- REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
- TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.

**-120 CONDENSER PLENUM BOX**

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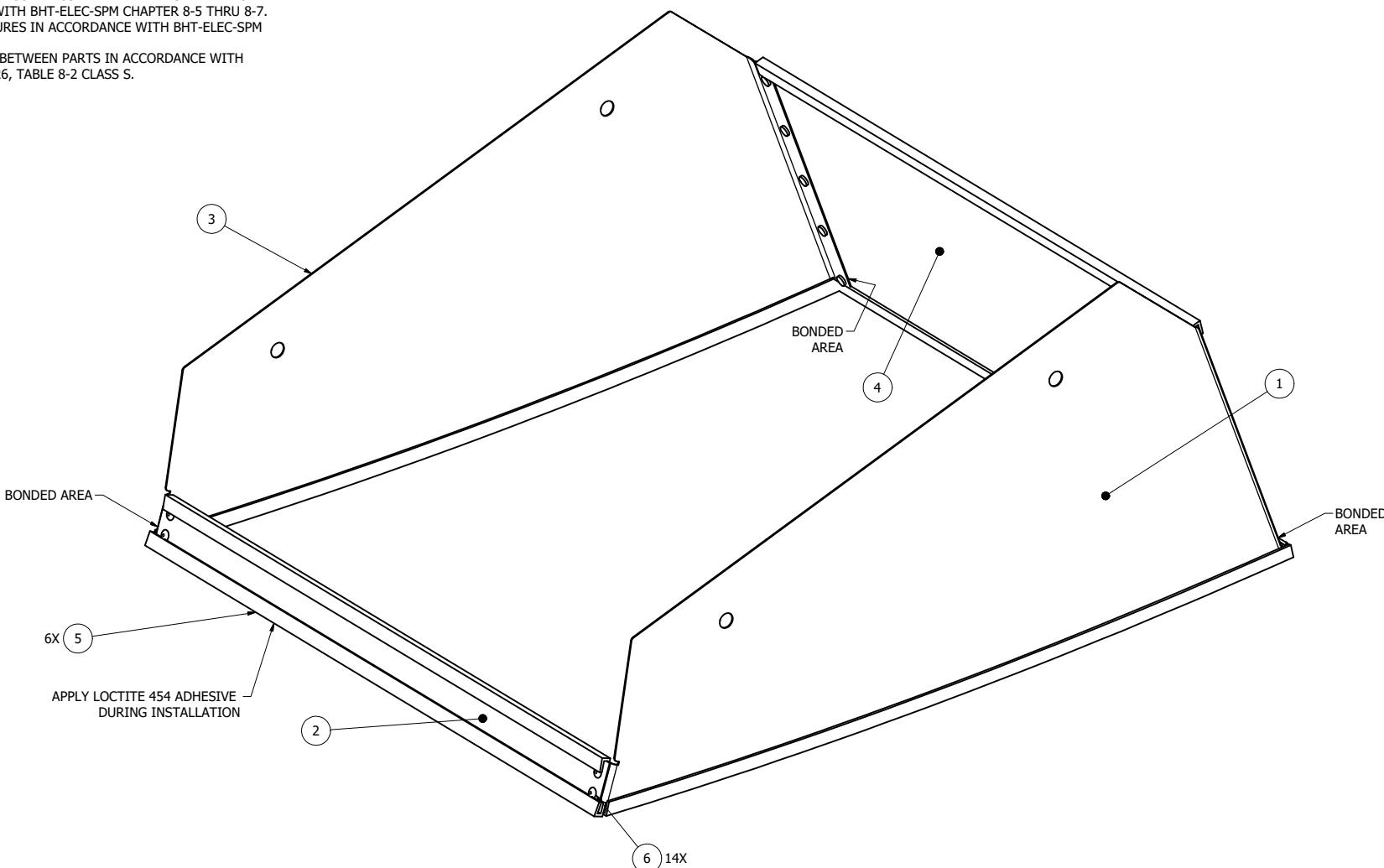
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-101	CONDENSER PLENUM LEFT SIDE
2	1	505AC-2300-102	CONDENSER PLENUM FRONT
3	1	505AC-2300-103	CONDENSER PLENUM RIGHT SIDE
4	1	505AC-2300-104	CONDENSER PLENUM AFT
5	6' 6"	ES00140-3	EXTRUDED RUBBER
6	14	MS20470AD3-3	RIVET

## NOTES:

1. WET INSTALL RIVETS WITH PRIMER PER MIL-PRF-23377J TYPE I, CLASS N
2. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPARED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
3. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
4. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.

**-121 CONDENSER OUTLET PLENUM ASSY**

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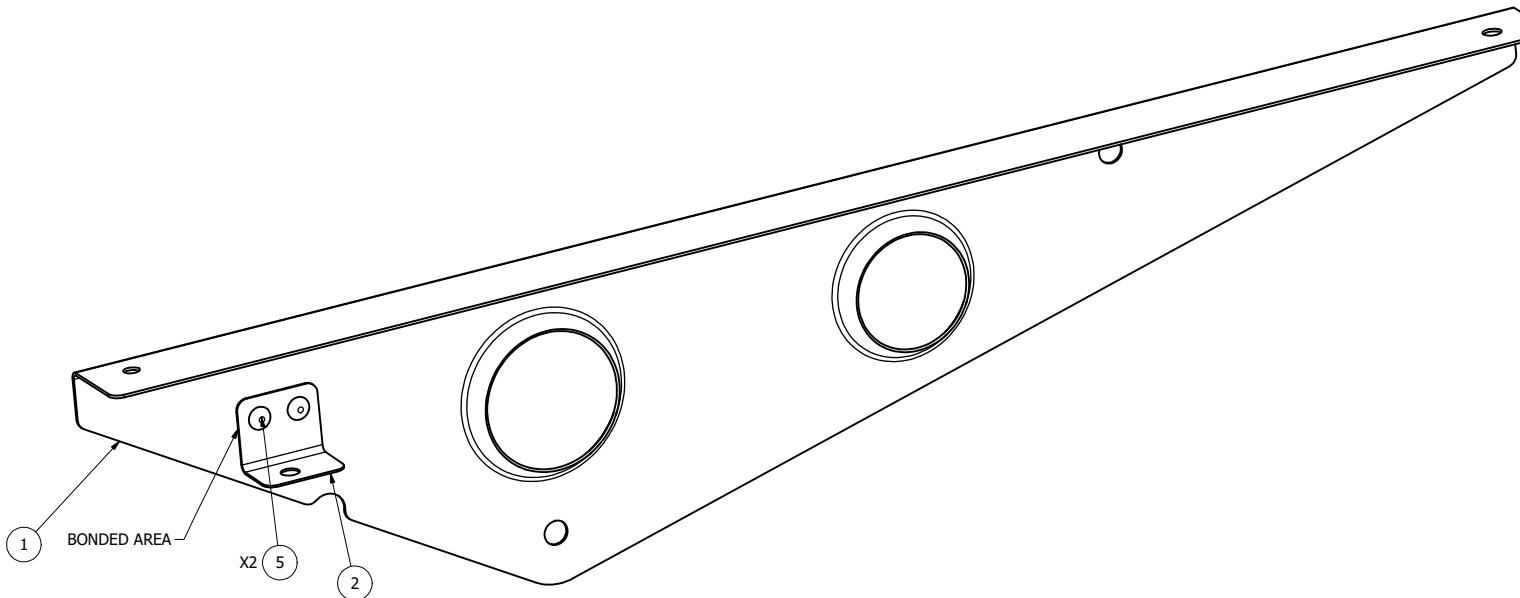
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DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
DO NOT SCALE DRAWING			SHEET 8 OF 23		
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-111	CONDENSER LEFT SIDE BRACKET
2	1	505AC-2300-127	TUBE SUPPORT
5	2	MS20470AD4-3-5	RIVET

D D  
NOTES:

1. WET INSTALL RIVETS WITH PRIMER PER MIL-PRF-23377J TYPE I, CLASS N
2. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPPED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
3. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
4. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.
5. PAINT: PRIMER PER MIL-PRF-23377J TYPE 1, CLASS N.

## **-122 CONDENSER LEFT SIDE ASSY**



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DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
DO NOT SCALE DRAWING			SHEET 9 OF 23		
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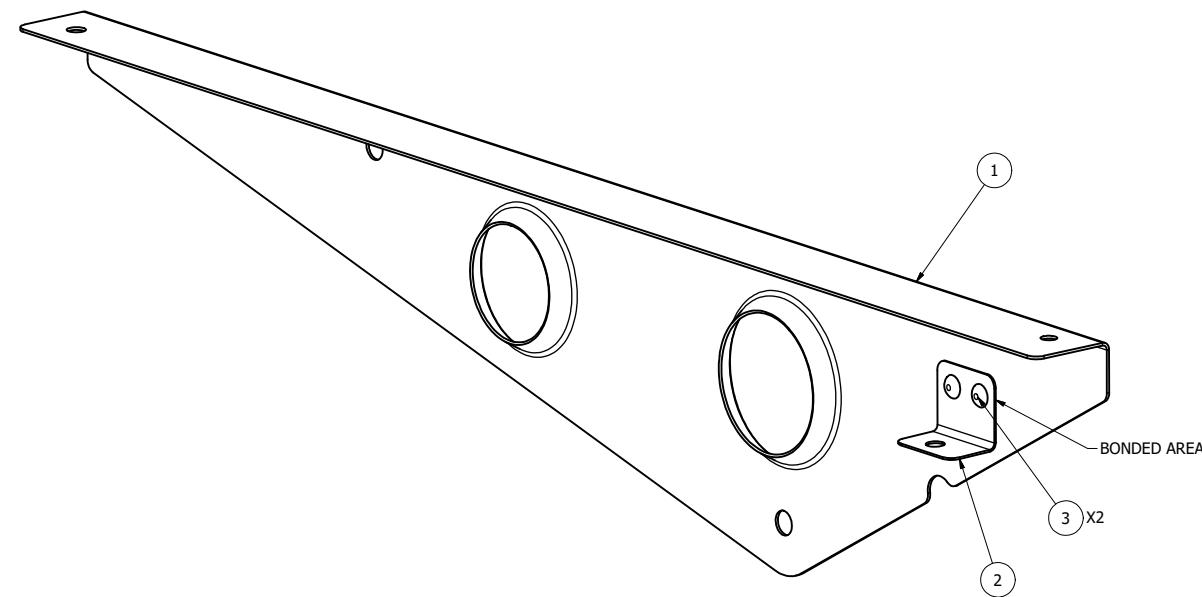
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PARTS LIST			
ITEM	QTY	PART NUMBER	DESCRIPTION
1	1	505AC-2300-112	CONDENSER RIGHT SIDE BRACKET
2	1	505AC-2300-127	TUBE SUPPORT
3	2	MS20470AD4-3-5	RIVET

## NOTES:

1. WET INSTALL RIVETS WITH PRIMER PER MIL-PRF-23377J TYPE I, CLASS N
2. ENSURE ANODIZE AND PAINT COATINGS BETWEEN PARTS ARE REMOVED AND PREPPED IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-5 THRU 8-7.
3. REFINISH BONDED STRUCTURES IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-25.
4. TEST BONDED RESISTANCE BETWEEN PARTS IN ACCORDANCE WITH BHT-ELEC-SPM CHAPTER 8-26, TABLE 8-2 CLASS S.
5. PAINT: PRIMER PER MIL-PRF-23377J TYPE 1, CLASS N.

**-123 CONDENSER RIGHT SIDE ASSY**

Paravion® Inc. Technology	TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
DO NOT SCALE DRAWING			SHEET 10 OF 23		
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		3RD ANGLE PROJECTION	

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PROTO

**-101 CONDENSER PLENUM LEFT SIDE**

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST:

NOTES:

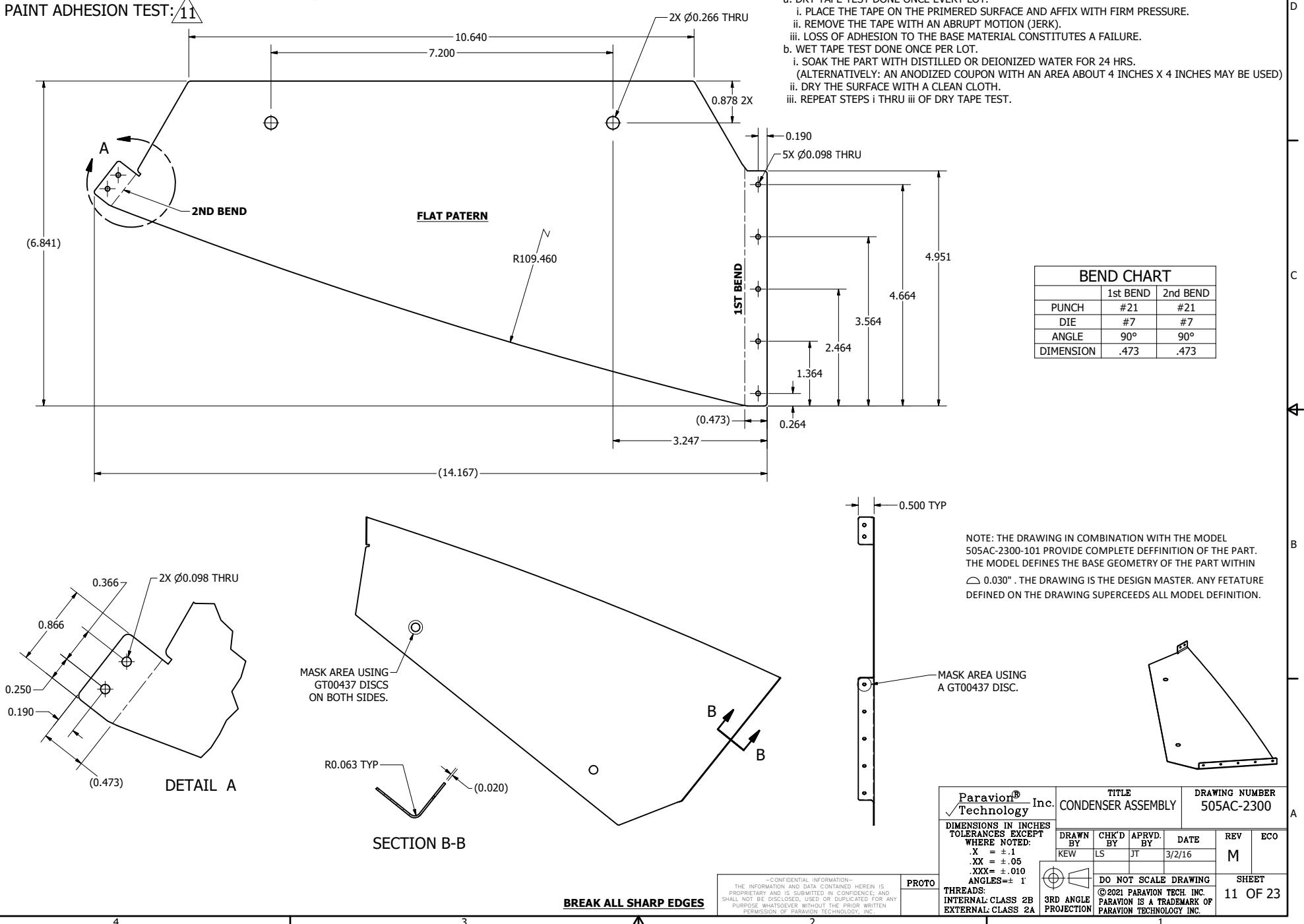
## 10. PREPARE PART FOR PRIMER:

- USE EXTRA CAUTION AND WEAR GLOVES WHILE PREPARING PARTS FOR PRIMER.
- THOROUGHLY CLEAN ANODIZED PART USING ISOPROPYL ALCOHOL.
- USE COMPRESSED AIR FREE OF WATER AND CONTAMINANTS.

## 11. PAINT ADHESION TEST:

FOR BOTH DRY AND WET TESTS, USE A TAPE WITH AN ADHESION TO STEEL OF 70 OZ/IN MINIMUM.

- DRY TAPE TEST DONE ONCE EVERY LOT.
  - PLACE THE TAPE ON THE PRIMERED SURFACE AND AFFIX WITH FIRM PRESSURE.
  - REMOVE THE TAPE WITH AN ABRUPT MOTION (JERK).
  - LOSS OF ADHESION TO THE BASE MATERIAL CONSTITUTES A FAILURE.
- WET TAPE TEST DONE ONCE PER LOT.
  - SOAK THE PART WITH DISTILLED OR DEIONIZED WATER FOR 24 HRS. (ALTERNATIVELY: AN ANODIZED COUPON WITH AN AREA ABOUT 4 INCHES X 4 INCHES MAY BE USED)
  - DRY THE SURFACE WITH A CLEAN CLOTH.
  - REPEAT STEPS i THRU iii OF DRY TAPE TEST.



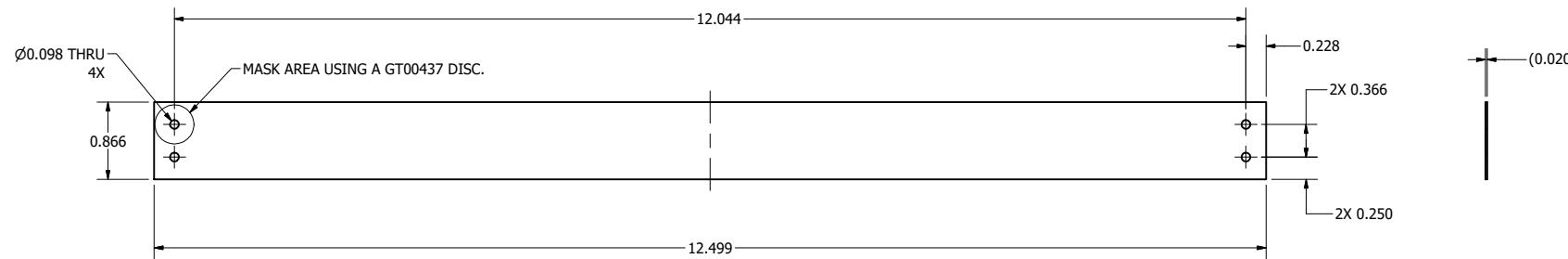
**-102 CONDENSER PLENUM FRONT 10**

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 11

**BREAK ALL SHARP EDGES**

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PROTO

Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300		A
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX= ± .010 ANGLES=± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
DO NOT SCALE DRAWING							
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	© 2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.	SHEET 12 OF 23				A

**-103 CONDENSER PLENUM RIGHT SIDE**

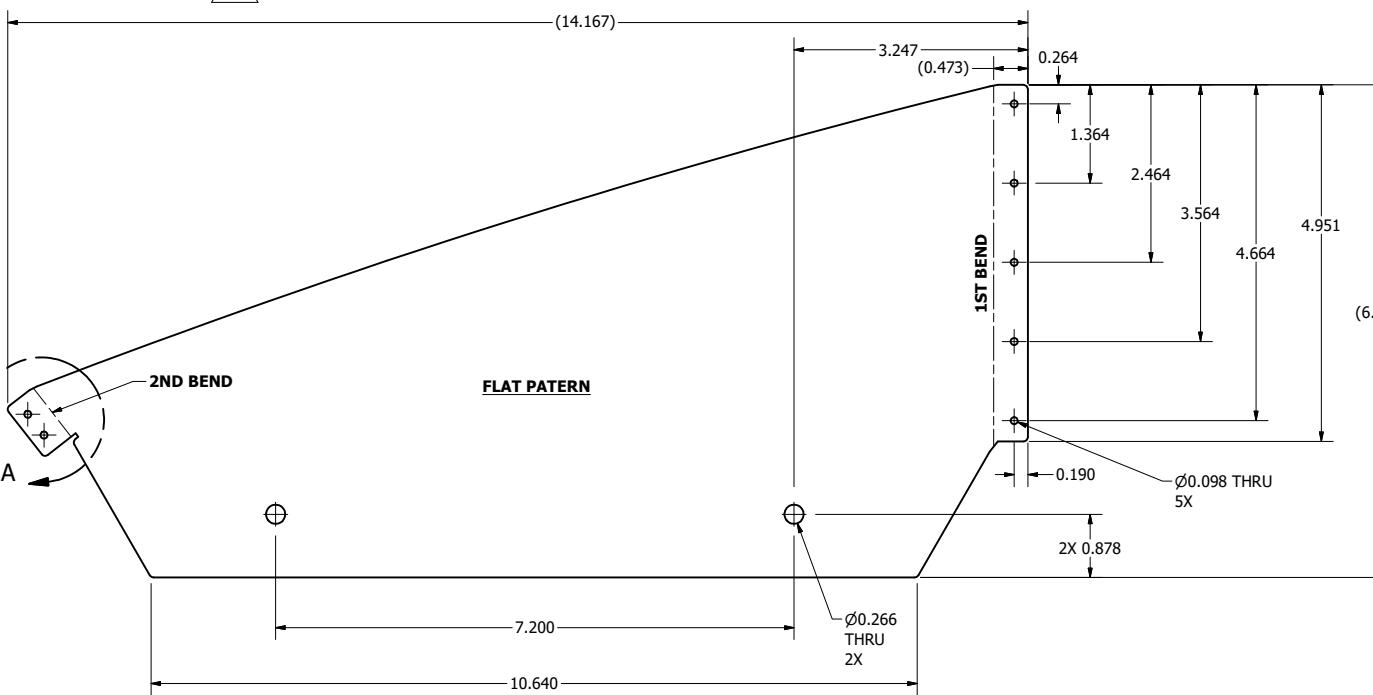
MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

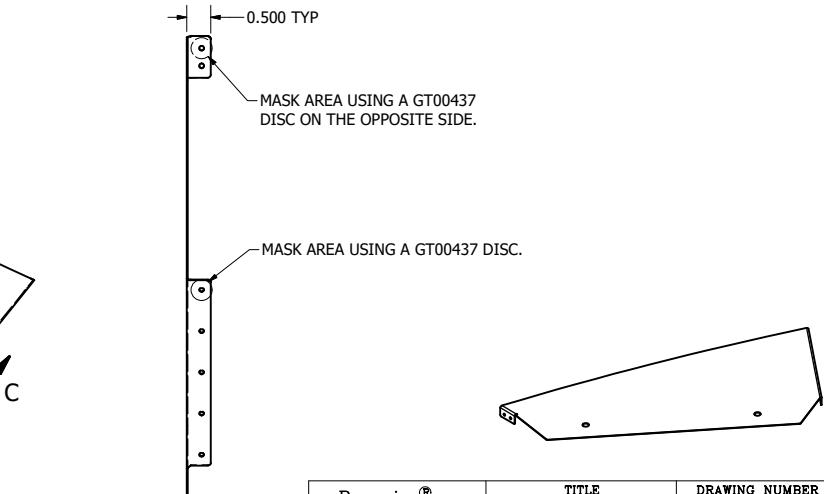
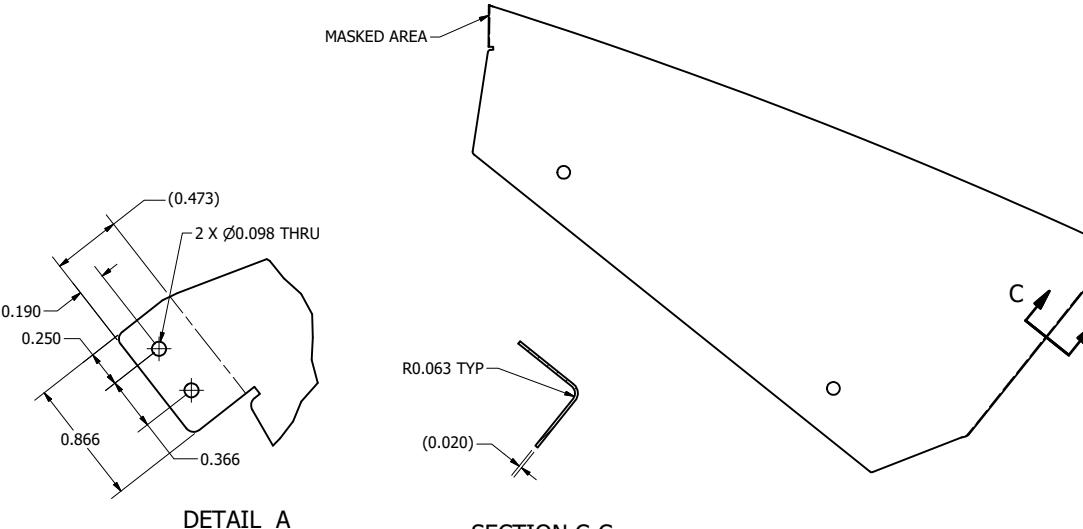
PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 11

NOTE: THE DRAWING IN COMBINATION WITH THE MODEL 505AC-2300-103 PROVIDE COMPLETE DEFINITION OF THE PART. THE MODEL DEFINES THE BASE GEOMETRY OF THE PART WITHIN  $\Delta 0.030"$ . THE DRAWING IS THE DESIGN MASTER. ANY FETATURE DEFINED ON THE DRAWING SUPERCEDES ALL MODEL DEFINITION.



BEND CHART		
	1st BEND	2nd BEND
PUNCH	#21	#21
DIE	#7	#7
ANGLE	90°	90°
DIMENSION	.473	.473



BREAK ALL SHARP EDGES

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PROTO

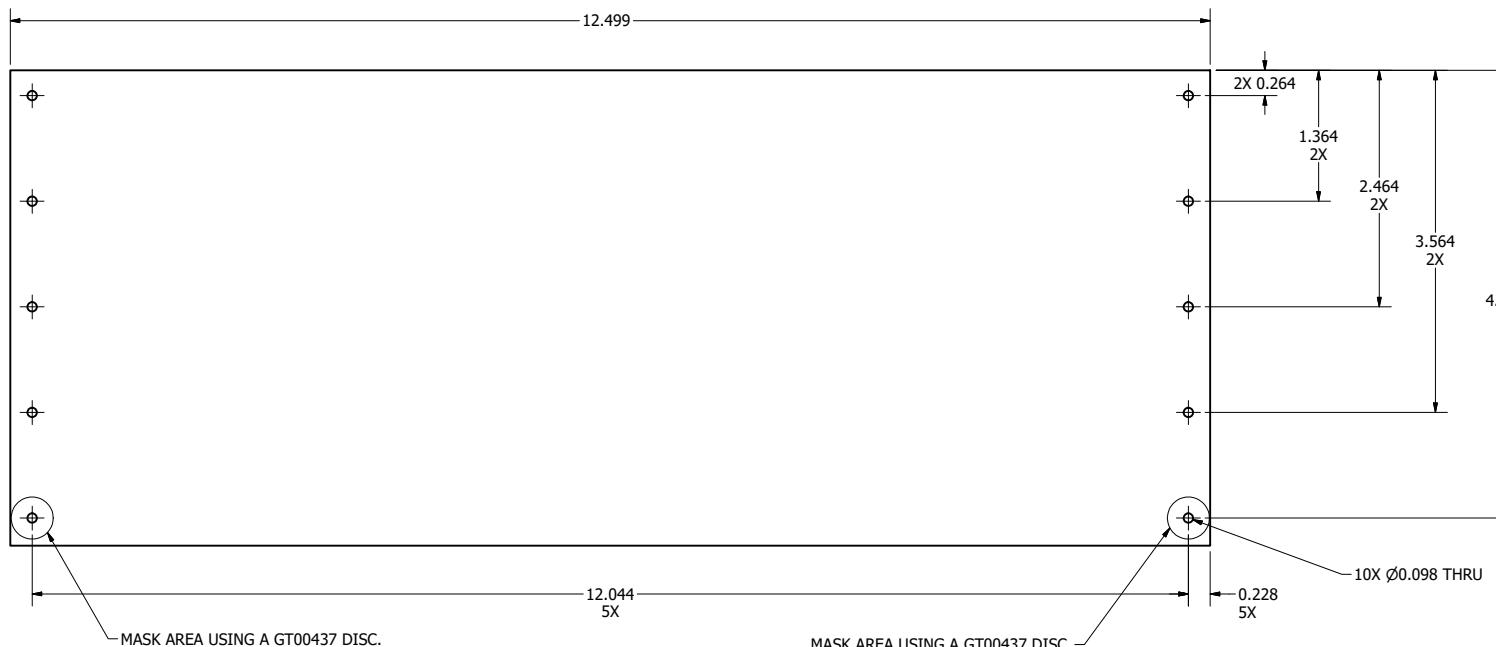
Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APRV'D BY JT	DATE 3/2/16	REV M	ECO
DO NOT SCALE DRAWING					
3RD ANGLE PROJECTION		© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.		SHEET 13 OF 23	

**-104 CONDENSER PLENUM AFT** 

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST:  11**BREAK ALL SHARP EDGES**

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Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M
DO NOT SCALE DRAWING						SHEET 14 OF 23
 INTERNAL: CLASS 2B EXTERNAL: CLASS 2A						© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.

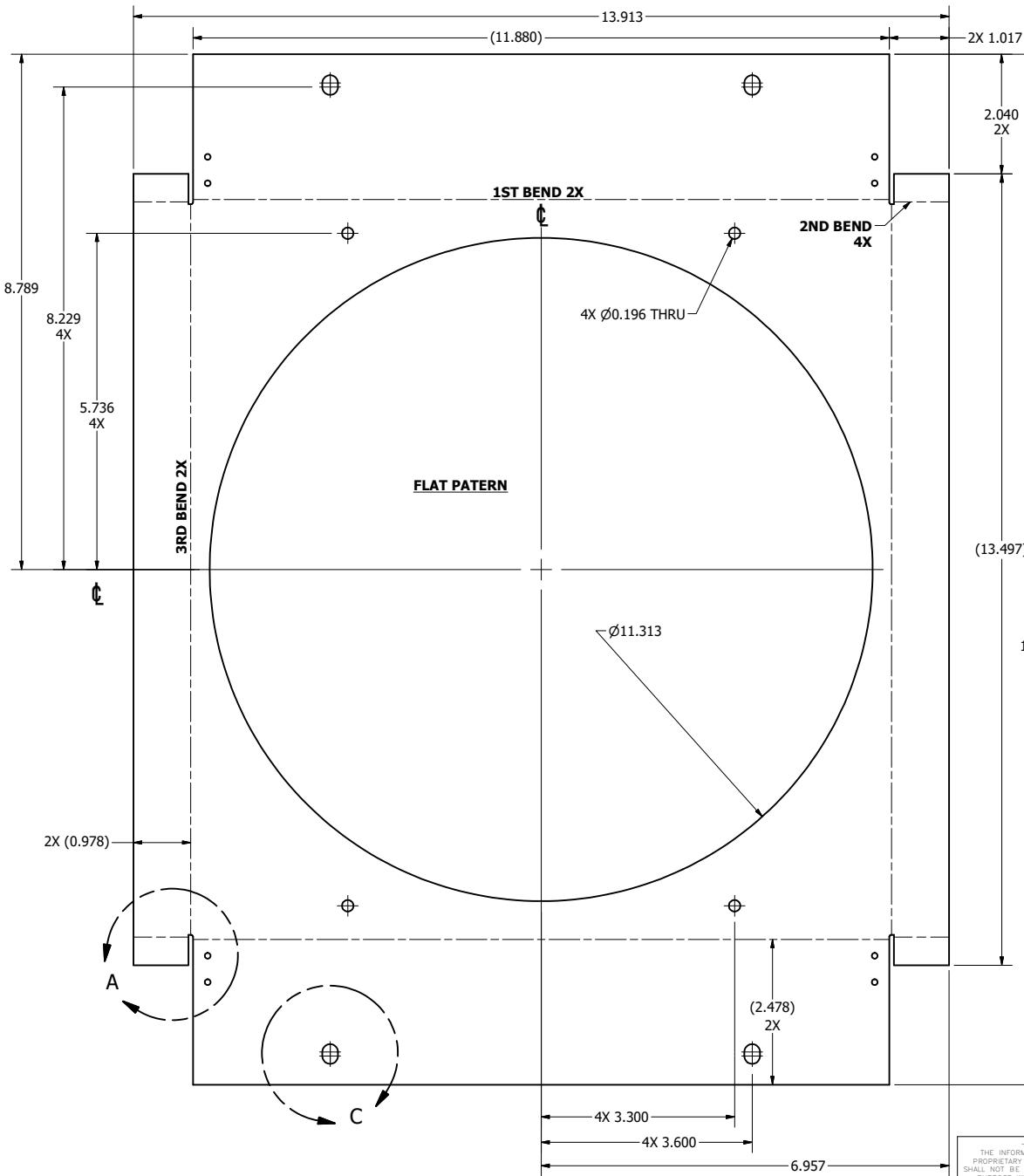
## **-105 CONDENSER PLENUM BOX**

MATERIAL: 0.025" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

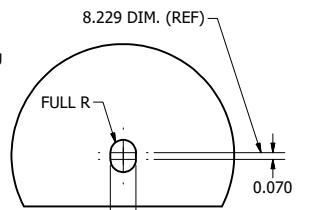
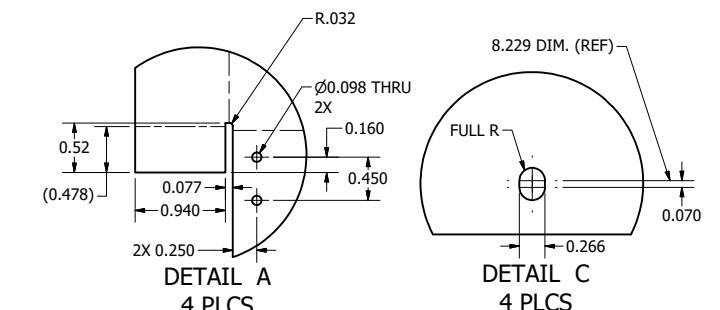
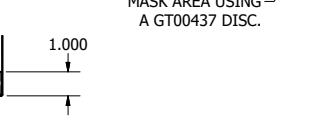
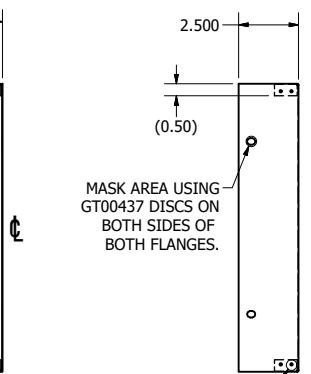
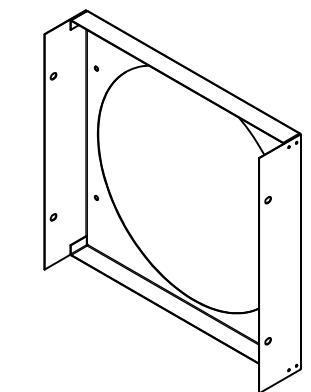
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2

**PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.**

## PAINT ADHESION TEST: 11



BEND CHART			
	1st BEND	2nd BEND	3rd BEND
PUNCH	#6	#6	#6
DIE	#15	#15	#1
ANGLE	80°	81°	84°
DIMENSION	.2470	.470	.962



4 PLCS	4 PLCS
Paravion® Inc.	TITLE CONDENSER ASSEMBLY DRAWING NUMBER 505AC-2300

✓ Technology	CONDENSER ASSEMBLY			303AC 2500		
	DIMENSIONS IN INCHES TOLERANCES EXCEPT	DRAWN	CHK'D	APRVD.	DATE	REV

WHERE NOTED:	BY	BY	BY	DATE
.X = ± .1 XX = ± .05	KEW	LS	JT	3/2/16

ERP EDGES	.XX = ± .05	XXX = ± .010		DO NOT SCALE DRAWING	SHEET
ERIEIN IS ENCE; AND	PROTO	ANGLES = ± 1°		©2021 PARAVION TECH INC	15 OF 22
THREADS:					

**BREAK ALL SHARP EDG**

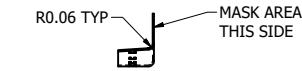
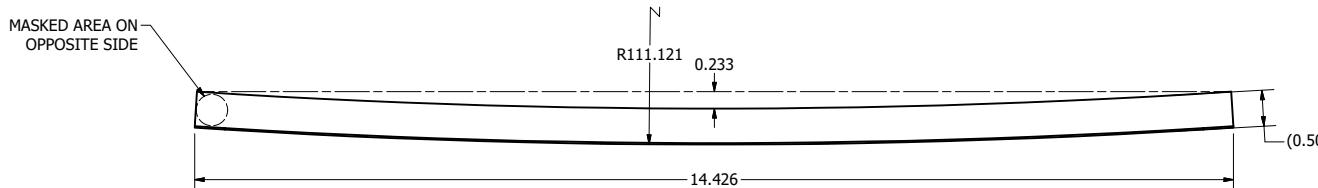
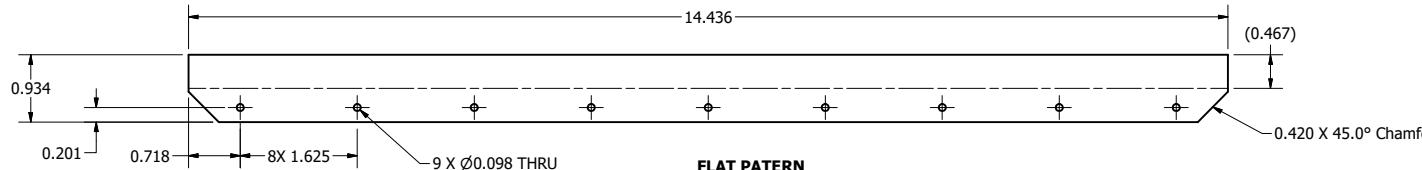
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Paravion® Technology		TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APRVD BY JT	DATE 3/2/16	REV M	ECO
 THREADS: INTERNAL: CLASS 2B		DO NOT SCALE DRAWING ©2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF					
3RD ANGLE		SHEET 15 OF 23					

**-106 CONDENSER FRAME SIDE**

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025  
 FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.  
 PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.  
 PAINT ADHESION TEST: 11



MASK AREA USING A GT00437 DISC.

**BREAK ALL SHARP EDGES**

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Paravion® Inc. Technology	TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
DO NOT SCALE DRAWING					SHEET 16 OF 23
 INTERNAL: CLASS 2B EXTERNAL: CLASS 2A					© 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.

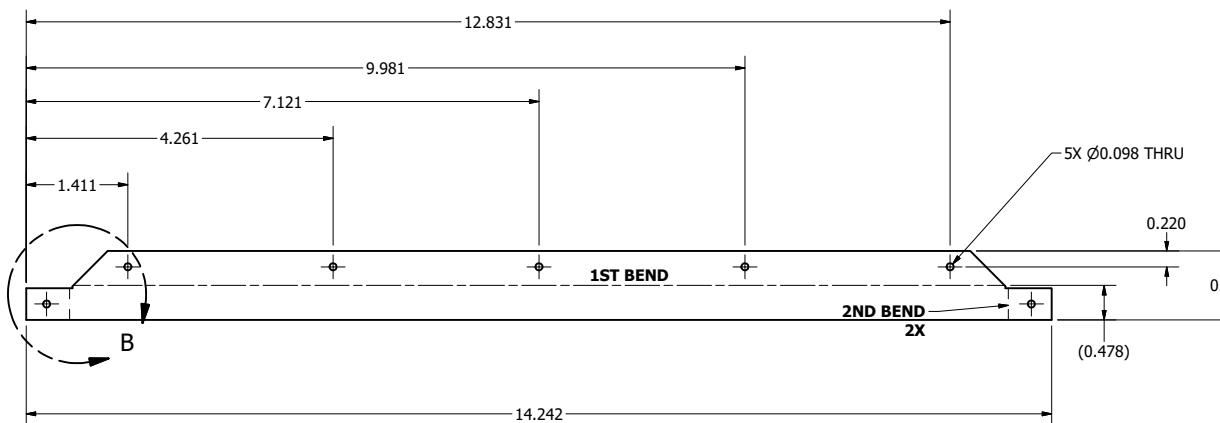
**-108 FOR/AFT FRAME 10**

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

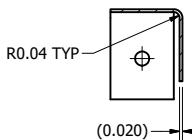
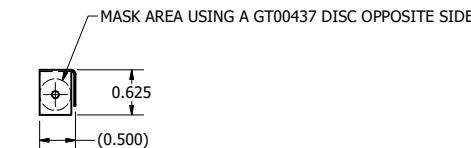
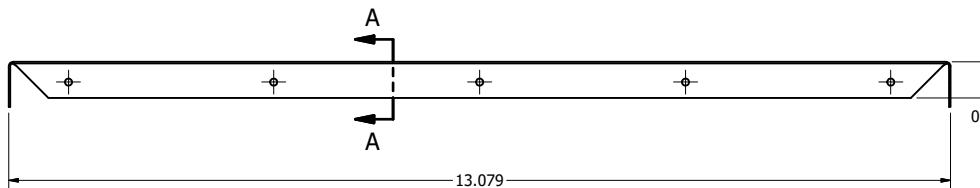
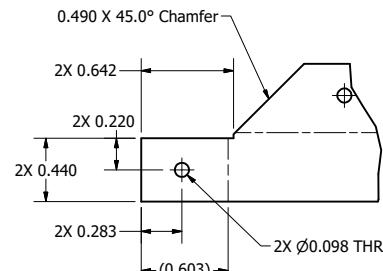
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 11

**FLAT PATTERN**

BEND CHART		
	1st BEND	2nd BEND
PUNCH	#21	#21
DIE	#1	#1
ANGLE	90°	92°
DIMENSION	.469	.592

**SECTION A-A****DETAIL B****BREAK ALL SHARP EDGES**

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DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
DO NOT SCALE DRAWING 3RD ANGLE PROJECTION			SHEET 17 OF 23		
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**-110 CONDENSER FORWARD BRACKET 10**

MATERIAL: 0.063" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

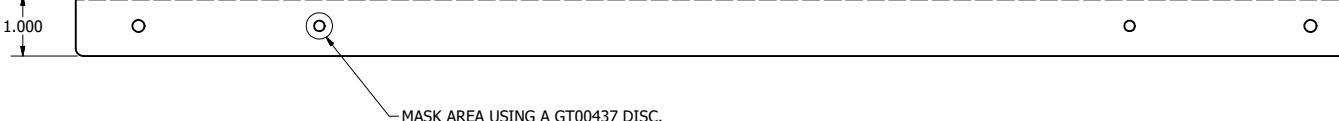
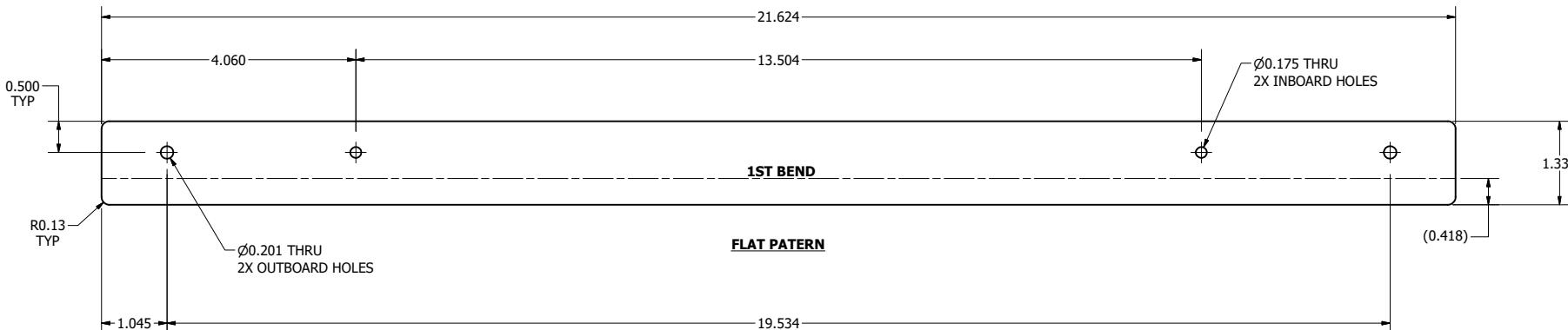
FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 11

**BEND CHART**

	1st BEND
PUNCH	#10
DIE	#1
ANGLE	68°
DIMENSION	.420

**BREAK ALL SHARP EDGES**

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Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°					
DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
DO NOT SCALE DRAWING					
3RD ANGLE PROJECTION		SHEET 18 OF 23			
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**-111 CONDENSER LEFT SIDE BRACKET**  10

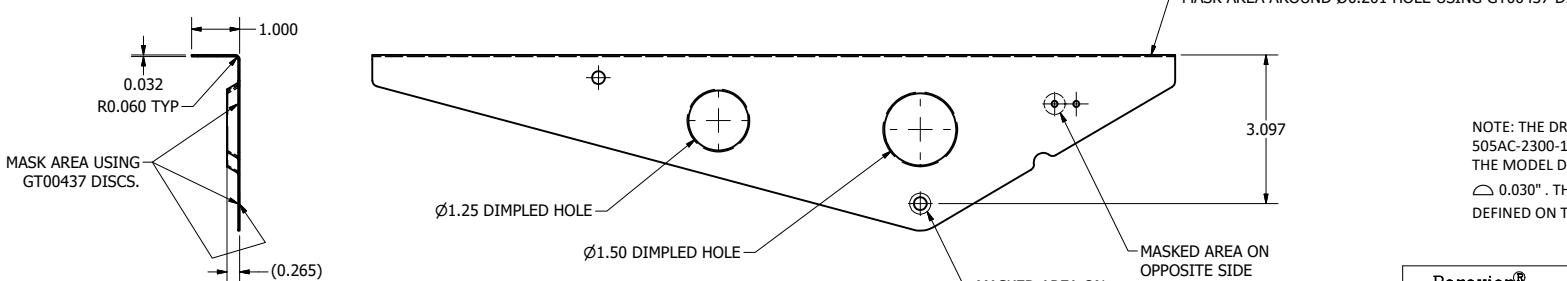
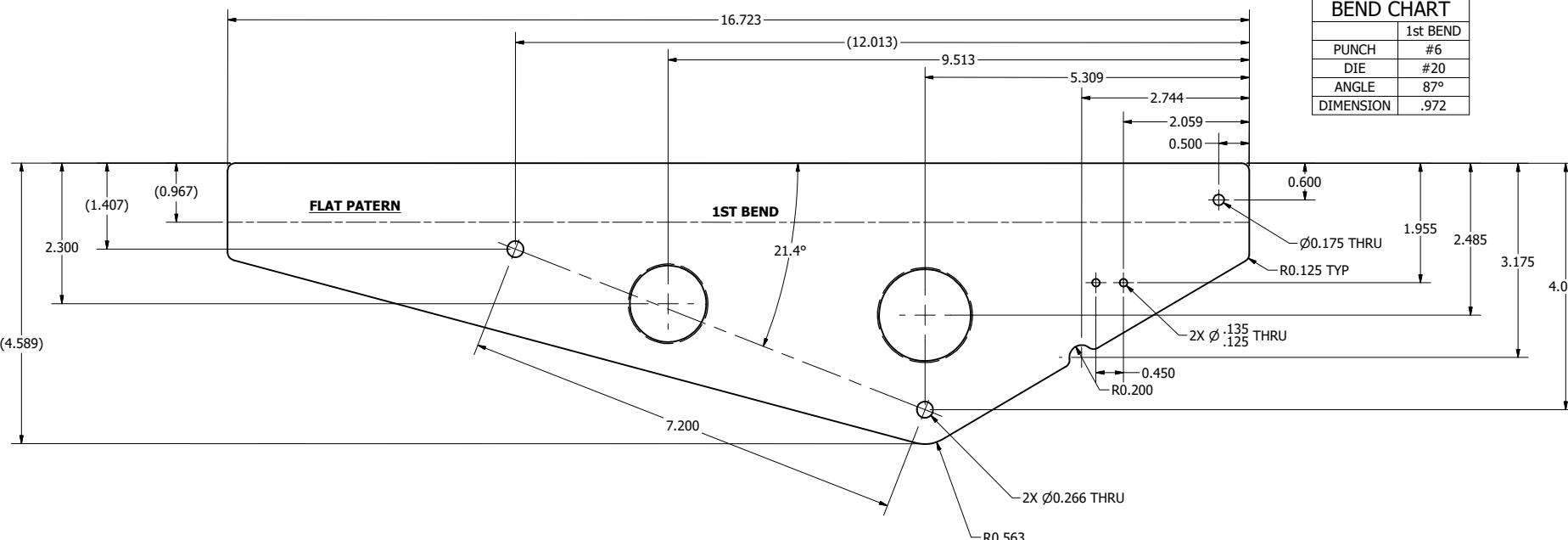
MATERIAL: 0.032" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST:  11

	BEND CHART
	1st BEND
PUNCH	#6
DIE	#20
ANGLE	87°
DIMENSION	.972

**BREAK ALL SHARP EDGES**

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PROTO

Paravion® Technology		TITLE		DRAWING NUMBER	
		CONDENSER ASSEMBLY		505AC-2300	
DIMENSIONS IN INCHES					
WHERE NOTED:		DRAWN BY	CHK'D BY	APRV'D BY	DATE
.X = ± .1		KEW	LS	JT	3/2/16
.XX = ± .05					
.XXX = ± .010					
ANGLES = ± 1°					
THREADS:		DO NOT SCALE DRAWING		SHEET	
INTERNAL: CLASS 2B		© 2021 PARAVION TECH, INC.		19 OF 23	
EXTERNAL: CLASS 2A		PARAVION IS A TRADEMARK OF			
		PARAVION TECHNOLOGY INC.			

**-112 CONDENSER RIGHT SIDE BRACKET**

10

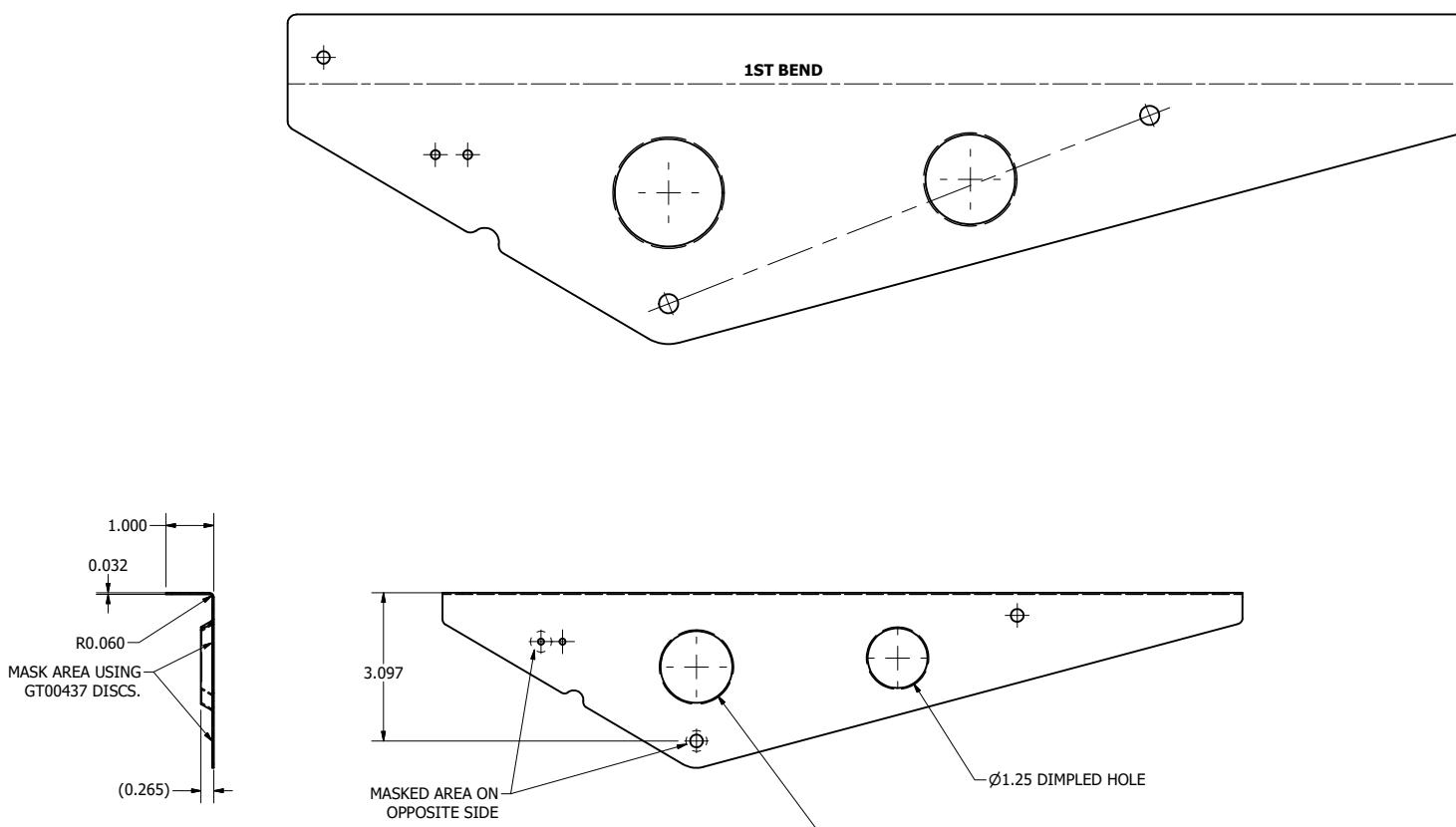
MATERIAL: 0.032" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: 11

BEND CHART	
	1st BEND
PUNCH	#6
DIE	#20
ANGLE	87°
DIMENSION	.972

**FLAT PATTERN  
SAME AS -111**

NOTE: THE DRAWING IN COMBINATION WITH THE MODEL 505AC-2300-112 PROVIDE COMPLETE DEFINITION OF THE PART. THE MODEL DEFINES THE BASE GEOMETRY OF THE PART WITHIN  $\Delta 0.030"$ . THE DRAWING IS THE DESIGN MASTER. ANY FEATURE DEFINED ON THE DRAWING SUPERCEDES ALL MODEL DEFINITION.

**BREAK ALL SHARP EDGES**

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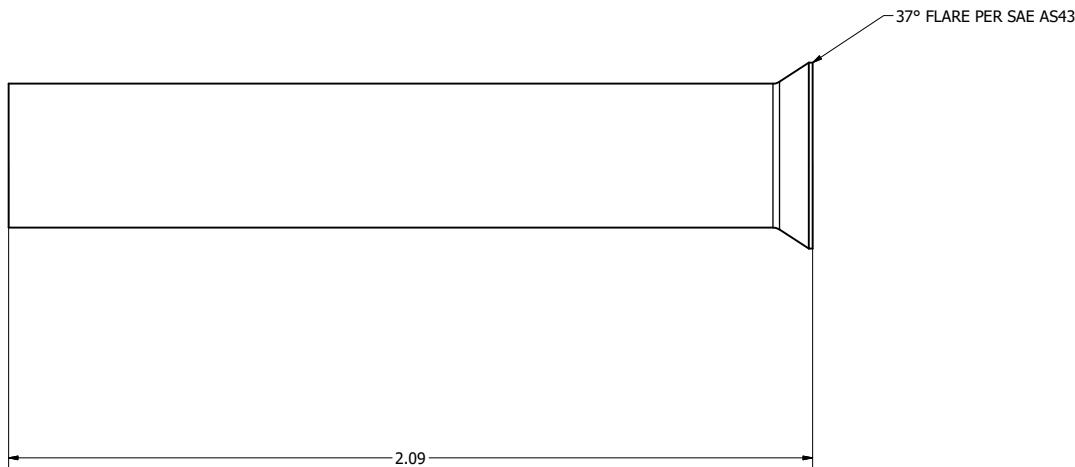
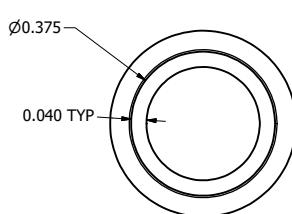
Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED:		DRAWN BY KEW	CHK'D BY LS	APPROVED BY JT	DATE 3/2/16
ANGLES=± 1°				REV M	ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	DO NOT SCALE DRAWING		SHEET 20 OF 23	
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**-116 TUBE**

MATERIAL: 0.375" OD X 0.040 WALL, COPPER ALLOY - C10200, C1200, OR C1220; ASTM - B698

ALTERNATE MATERIAL: ES40100-6

FINISH: NONE

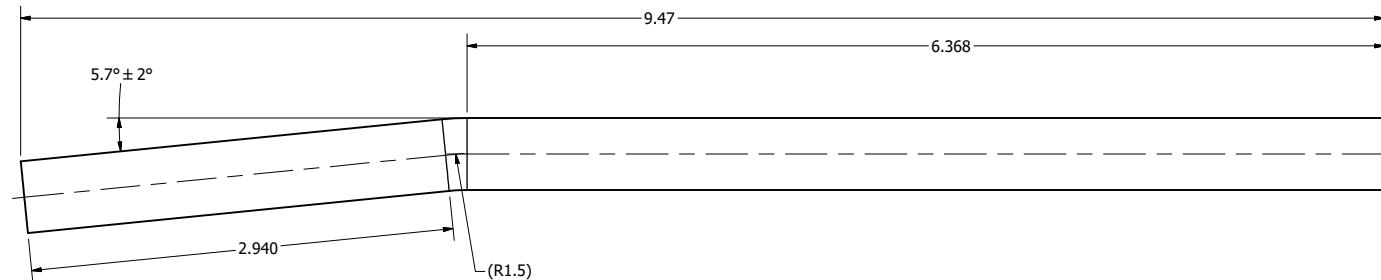
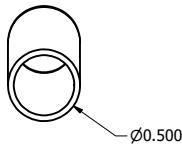
**BREAK ALL SHARP EDGES****-117 TUBE**

MATERIAL: 0.500" OD X 0.040 WALL, COPPER ALLOY - C10200, C1200, OR C1220; ASTM - B698

ALTERNATE MATERIAL: ES40100-8

STOCK TUBE LENGTH: 9.40"

FINISH: NONE

**BREAK ALL SHARP EDGES**

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PROTO

Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A	3RD ANGLE PROJECTION	DO NOT SCALE DRAWING © 2021 PARAVION TECH, INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.					
SHEET 21 OF 23							

**-119 SCREEN**

MAKE FROM: ES04071-1 (MATERIAL 304S. ST.)  
FINISH: NONE

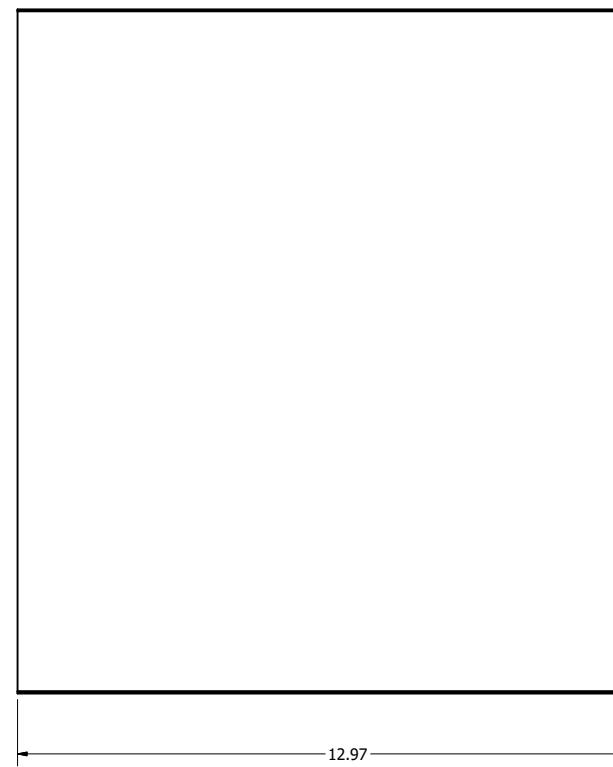
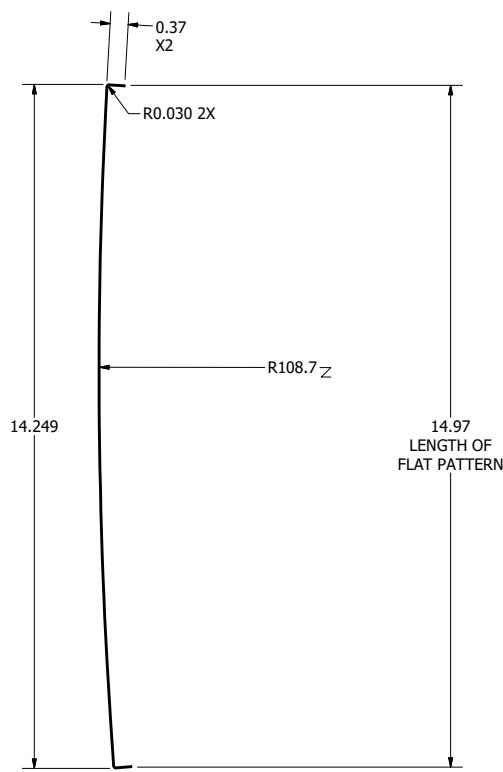
**BOTH BENDS**

PUNCH #21

DIE #7

ANGLE @ 87°

DIMENSION .320

**BREAK ALL SHARP EDGES**

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PURPOSE WHATSOEVER WITHOUT THE PRIOR WRITTEN  
PERMISSION OF PARAVION TECHNOLOGY, INC.

PROTO

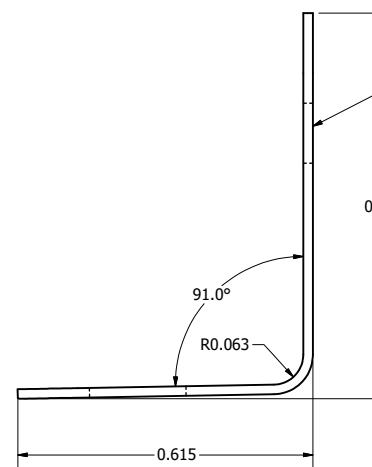
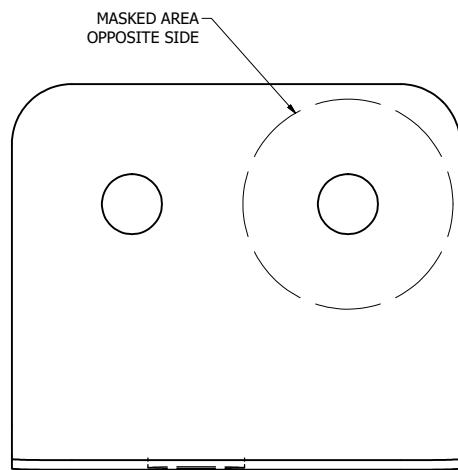
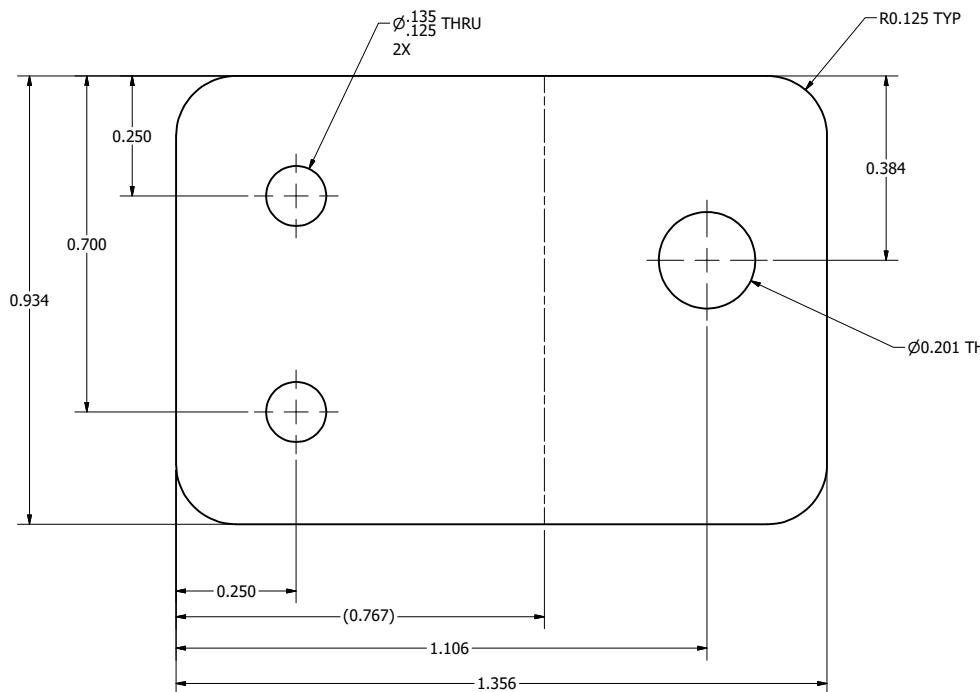
Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY			DRAWING NUMBER 505AC-2300		
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16	REV M	ECO
	DO NOT SCALE DRAWING						
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A						© 2021 PARAVION TECH. INC. PARAVION IS A TRADEMARK OF PARAVION TECHNOLOGY INC.	SHEET 22 OF 23

**-127 TUBE SUPPORT <sup>10</sup>**

MATERIAL: 0.020" THK 6061-T6 SHEET PER QQ-A-250/11 AMS 4027, 4026, 4025

FINISH: ANODIZE PER MIL-A-8625 TYP II, CLASS 1, EXCEPT OMIT SEALING IN SECTION 3.8.1.2.

PAINT: PRIMER PER MIL-PRF-23377J TYPE I, CLASS N.

PAINT ADHESION TEST: <sup>11</sup>**BREAK ALL SHARP EDGES**

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Paravion® Inc. Technology		TITLE CONDENSER ASSEMBLY		DRAWING NUMBER 505AC-2300	
DIMENSIONS IN INCHES TOLERANCES EXCEPT WHERE NOTED: .X = ± .1 .XX = ± .05 .XXX = ± .010 ANGLES = ± 1°		DRAWN BY KEW	CHK'D BY LS	APPVD. BY JT	DATE 3/2/16
THREADS: INTERNAL: CLASS 2B EXTERNAL: CLASS 2A		DO NOT SCALE DRAWING 3RD ANGLE PROJECTION		REV M ECO	
4	1	3	2	1	A